

Work Order ID 82026

82026

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March-22-12 10:22:44 AM

Item ID: D2877 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Spacer
 Start Date: 22/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 12/03/22 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2877	Rev B					(40)			

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2877 Dwg Rev: B Prog Rev: B 2-
 deburr
6061 .125 1812-4-22

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control 1812-4-22

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control 812/4/23 count (40) 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 22/03/2012 Start Qty: 40.00

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Required Date: 05/04/2012 Req'd Qty: 40.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

(Handwritten signature) 12-4-23

(Handwritten signature) 12-4-23

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>2e</u>	0.00							
160									
Packaging	Memo	0.00				40			12/4/23
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							12/4/23
Quality Control									

12-04-23

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Picklist Print

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Work Order ID: 82026

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Parent Item: D2877

D2877

Parent Item Name: Saddle Spacer

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP B 00.05.19 Added inspect level 8EC
 IPP C 06.04.26 Water jet EC
 IPP Rev:D Now M6061-T6 06-06-23 JLM
 IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			110	sf	88.3800	0.0607	2.555789			

M6061T6S 125

6061-T6 .125 Sheet

**

B12-4-22

(40)

Location	Loc Qty	Loc Code
MAT021	88.38	
113608	46.69	
118217	0.09	
119513	10.8	
120218	30.8	

121437

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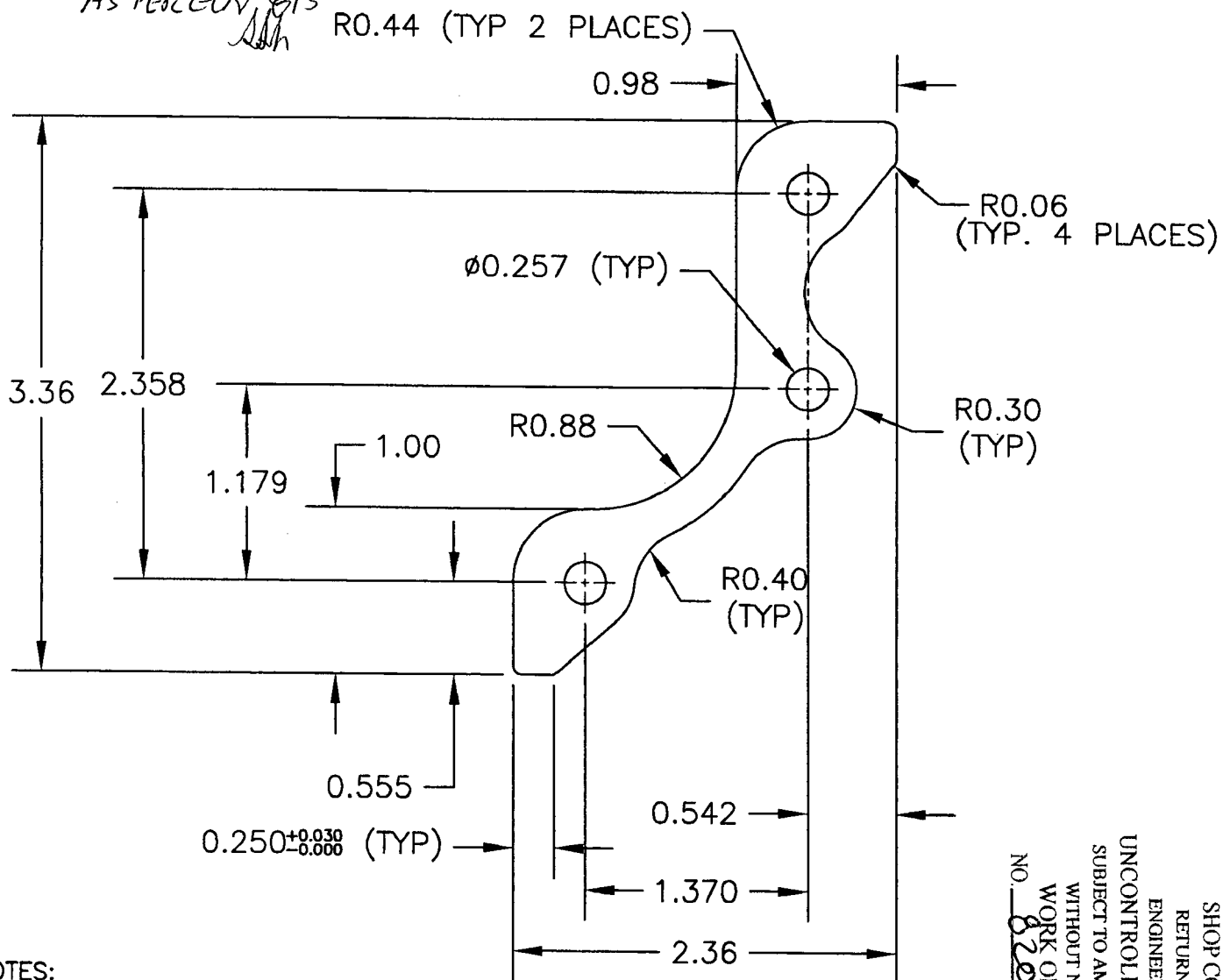
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
*06.06.21.**AS PER ECN 013***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82026MCS
12/03/22

Dart Aerospace Ltd

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